

Process Sheet

SPLIT-2

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 45392 -2
Estimate Number : 10897
P.O. Number :
This Issue : 02/02/2009 S.O. No. :
Prsht Rev. : NC
First Issue : 11 Type : MACHINED PARTS
Previous Run : 42169
Written By :
Checked & Approved By : 09.02.02
Comment : Est Rev:F Re-format 05-11-22 JLM

Drawing Name : BUSHING

Part Number : D2618
Drawing Number : D2618 REV B1
Project Number : N/A
Drawing Revision : B1
Material : N/A
Due Date : 12/02/2009

Qty: 300 Um: Each

223 c4

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 MDELINR0750 Delrin Round Bar 0.75"



Comment: Qty.: 0.2709 f(s)/Unit Total: 81.2700 f(s)
Delrin Round Bar .75" black

Batch: M109571

SA / 09/02/17

* NO MORE STOCK
* NOT REMOVED FROM COMP. INV.

JML / 09/02/04

77

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA195 & Dwg D2618.

2-Deburr

SA 09/02/17 (69P)
SA 09/02/15 (46 pcs)
25 scrap
21 pcs

JML / 09/02/04

104
PTO

77

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 09/02/15 / 09/02/11

JML / 09/02/04

77

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SA 09/02/23

SA 09/02/06

104

77

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST39

ST39 / 88 09/02/23

SA 09/02/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2618 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>45392 -2</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/02/17 P	2.0	Holes off center +.005, holes too small $\phi 303 \rightarrow .315 - 0.000$ too small $3,100 \pm .010 \rightarrow AC 3.075$ RC \rightarrow Programming errors previous shift $\{ 25$ pcs scrap3	UP 09.02.23 pu QSI 042	SCRAP QTY(10), DID NOT FIT ANS BOLT. REST ARE OK New prog Created. Old Prog is No Av.	P 09/02/22 Jmpe 22.01.02.23	S 09.02.23 pu QSI 042	UP 09.02.23 pu QSI 042	S 09.02.23

NOTE: Date & initial all entries

te:
ser:

Monday, 02/02/2009 11:50:03 AM
Julie Dawson

Process Sheet

Drawing Name: BUSHING

Customer: CU-DAR001 Dart Helicopters Services

Job Number: 45392

Part Number: D2618

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/02/24

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion







MF 09-09-23

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

[illegible]

Measured by:		Audited by:		Prototype Approval:	N/A
Date:	09/02/04	Date:	09/02/06	Date:	N/A

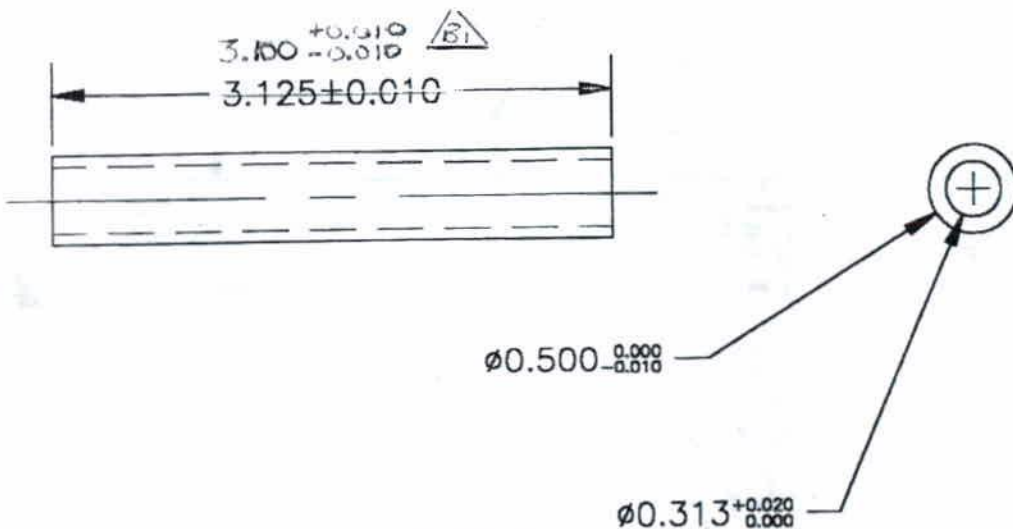
Rev	Date	Change	Revised by	Approved
A	04.08.26	New Issue	KJ/JLM	
B	04.09.10	Changed tolerance for Ø0.500	KJ/JLM	 

DART



DESIGN <i>BW</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>BW</i>	APPROVED <i>BW</i>	DRAWING NO. D2618	REV. B SHEET 1 OF 1
DATE 96:10:30		TITLE BUSHING	SCALE 1:1
B	97.05.09	3.125 WAS 1.625, .313 WAS .375	
01	<i>4/8</i> 04.06.03	CHANGE DIM FOR BETTER FIT	

RELEASED
97/05/13 DS



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WORK ORDER
NO. *AS392*